

Indexable drills

News 2024



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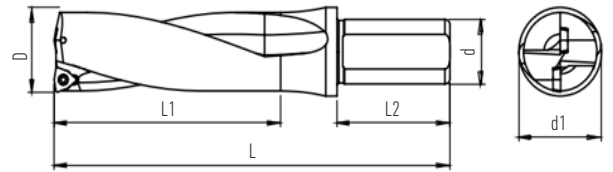
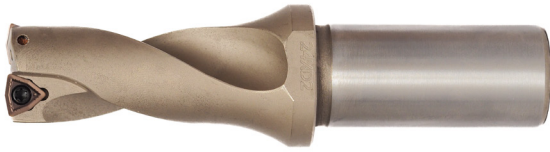


ETGS

Drill V3100 with inserts



DRILLING DEPTH 2xD / internal coolant supply 



Cylindrical shank with flat

Order code	Dimensions (mm)						Insert	Screw	Key
	D	d	d1	L	L1	L2			
V3100.16.V25.D2	16	25	34	110	32	54	WPMT 033208 (1,2 Nm)	TMSV-M2,5x6	T08
V3100.16.5.V25.D2	16,5	25	34	112	33	56			
V3100.17.V25.D2	17	25	34	112	34	56			
V3100.17.5.V25.D2	17,5	25	34	114	35	56			
V3100.18.V25.D2	18	25	34	114	36	56			
V3100.18.5.V25.D2	18,5	25	34	116	37	56			
V3100.19.V25.D2	19	25	34	116	38	56			
V3100.19.5.V25.D2	19,5	25	34	119	39	56			
V3100.20.V25.D2	20	25	34	119	40	56			
V3100.20.5.V25.D2	20,5	25	34	122	41	56			
V3100.21.V25.D2	21	25	34	122	42	56	WPMT 043208 (1,2 Nm)	TMSW-M2,5x7	T10
V3100.21.5.V25.D2	21,5	25	34	125	43	56			
V3100.22.V25.D2	22	25	34	125	44	56			
V3100.22.5.V25.D2	22,5	25	34	128	45	56			
V3100.23.V25.D2	23	25	34	128	46	56			
V3100.23.5.V25.D2	23,5	25	34	129	47	56			
V3100.24.V25.D2	24	25	34	129	48	56			
V3100.24.5.V25.D2	24,5	25	34	131	49	56			
V3100.25.V25.D2	25	25	34	131	50	56			
V3100.25.5.V25.D2	25,5	25	34	134	51	56			
V3100.26.V25.D2	26	25	34	134	52	56	WPMT 053308 (1,9 Nm)	TMSV-M3x8	T10
V3100.26.5.V25.D2	26,5	25	34	137	53	56			
V3100.27.V25.D2	27	25	34	137	54	56			
V3100.27.5.V25.D2	27,5	25	34	140	55	56			
V3100.28.V25.D2	28	25	34	140	56	56			

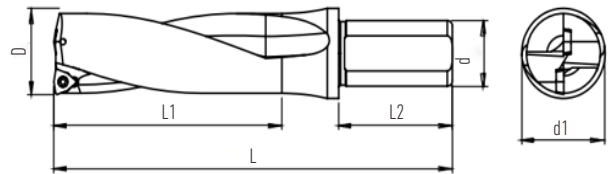
* Drilling tolerance + - 0,2 mm

Order code	Dimensions (mm)						Insert	Screw	Key
	D	d	d1	L	L1	L2			
V3100.28.5.V25.D2	28,5	25	34	140	57	56	WPMT 053308	TMSV-M3x8	T10
V3100.29.V25.D2	29	25	34	143	58	56			
V3100.29.5.V25.D2	29,5	25	34	143	59	56			
V3100.30.V32.D2	30	32	44	150	60	60	WPMT 063308 (2,9 Nm)	TMSV-M3,5x10	T15
V3100.31.V32.D2	31	32	44	153	62	60			
V3100.32.V32.D2	32	32	44	156	64	60			
V3100.33.V32.D2	33	32	44	159	66	60			
V3100.34.V32.D2	34	32	44	162	68	60			
V3100.35.V32.D2	35	32	44	165	70	60			
V3100.36.V32.D2	36	32	44	168	72	60			
V3100.37.V32.D2	37	32	44	171	74	60			
V3100.38.V32.D2	38	32	44	174	76	60			
V3100.39.V32.D2	39	32	44	177	78	60			
V3100.40.V32.D2	40	32	44	180	80	60	WPMT 083412 (4,3 Nm)	TMSV-M4x11	T15
V3100.41.V32.D2	41	32	44	183	82	60			
V3100.42.V32.D2	42	32	44	186	84	60			
V3100.43.V32.D2	43	32	44	189	86	60			
V3100.44.V32.D2	44	32	44	192	88	60			
V3100.45.V40.D2	45	40	54	195	90	70			
V3100.46.V40.D2	46	40	54	198	92	70			
V3100.47.V40.D2	47	40	54	201	94	70			
V3100.48.V40.D2	48	40	54	204	96	70			
V3100.49.V40.D2	49	40	54	207	98	70			
V3100.50.V40.D2	50	40	54	210	100	70			

Drill V3100 with inserts



DRILLING DEPTH 3xD / internal coolant supply 



Cylindrical shank with flat

Order code	Dimensions (mm)						Insert	Screw	Key			
	D	d	d1	L	L1	L2						
V3100.15.5.V25.D3	15,5	25	34	126	46,5	56	WPMT 033208 (1,2 Nm)	TMSV-M2,5x6	T08			
V3100.16.V25.D3	16	25	34	126	48	56						
V3100.16.5.V25.D3	16,5	25	34	129	49,5	56						
V3100.17.V25.D3	17	25	34	129	51	56						
V3100.17.5.V25.D3	17,5	25	34	132	52,5	56						
V3100.18.V25.D3	18	25	34	132	54	56						
V3100.18.5.V25.D3	18,5	25	34	135	55,5	56						
V3100.19.V25.D3	19	25	34	135	57	56						
V3100.19.5.V25.D3	19,5	25	34	139	58,8	56						
V3100.20.V25.D3	20	25	34	139	60	56						
V3100.20.5.V25.D3	20,5	25	34	143	61,5	56	WPMT 043208 (1,2 Nm)	TMSV-M2,5x7	T08			
V3100.21.V25.D3	21	25	34	143	63	56						
V3100.21.5.V25.D3	21,5	25	34	147	64,5	56						
V3100.22.V25.D3	22	25	34	147	66	56						
V3100.22.5.V25.D3	22,5	25	34	151	67,5	56						
V3100.23.V25.D3	23	25	34	151	69	56						
V3100.23.5.V25.D3	23,5	25	34	153	70,5	56						
V3100.24.V25.D3	24	25	34	153	72	56				WPMT 053308 (1,9 Nm)	TMSV-M3x8	T10
V3100.24.5.V25.D3	24,5	25	34	156	73,5	56						
V3100.25.V25.D3	25	25	34	156	75	56						
V3100.25.5.V25.D3	25,5	25	34	160	76,5	56						
V3100.26.V25.D3	26	25	34	160	78	56						
V3100.26.5.V25.D3	26,5	25	34	164	79,5	56						
V3100.27.V25.D3	27	25	34	164	81	56						
V3100.27.5.V25.D3	27,5	25	34	168	82,5	56						
V3100.28.V25.D3	28	25	34	168	84	56						
V3100.28.5.V25.D3	28,5	25	34	172	85,5	56						
V3100.29.V25.D3	29	25	34	172	87	56						
V3100.29.5.V25.D3	29,5	25	34	172	88,5	56						

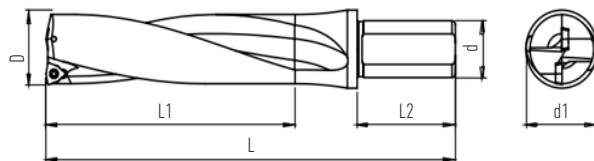
* Drilling tolerance + - 0,2 mm

Order code	Dimensions (mm)						Insert	Screw	Key
	D	d	d1	L	L1	L2			
V3100.30.V32.D3	30	32	44	180	90	60	WPMT 063308 (2,9 Nm)	TMSV-M3,5x10	T15
V3100.30.5.V32.D3	30,5	32	44	184	91,5	60			
V3100.31.V32.D3	31	32	44	184	93	60			
V3100.31.5.V32.D3	31,5	32	44	188	94,5	60			
V3100.32.V32.D3	32	32	44	188	96	60			
V3100.32.5.V32.D3	32,5	32	44	192	97,5	60			
V3100.33.V32.D3	33	32	44	192	99	60			
V3100.33.5.V32.D3	33,5	32	44	192	100,5	60			
V3100.34.V32.D3	34	32	44	192	102	60			
V3100.34.5.V32.D3	34,5	32	44	200	103,5	60			
V3100.35.V32.D3	35	32	44	200	105	60	WPMT 083412 (4,3 Nm)	TMSV-M4x11	T15
V3100.35.5.V32.D3	35,5	32	44	204	106,5	60			
V3100.36.V32.D3	36	32	44	204	108	60			
V3100.36.5.V32.D3	36,5	32	44	208	109,5	60			
V3100.37.V32.D3	37	32	44	208	111	60			
V3100.37.5.V32.D3	37,5	32	44	212	112,5	60			
V3100.38.V32.D3	38	32	44	212	114	60			
V3100.38.5.V32.D3	38,5	32	44	216	115,5	60			
V3100.39.V32.D3	39	32	44	216	117	60			
V3100.39.5.V32.D3	39,5	32	44	220	118,5	60			
V3100.40.V32.D3	40	32	44	220	120	60	WPMT 083412 (4,3 Nm)	TMSV-M4x11	T15
V3100.41.V32.D3	41	32	44	223	123	60			
V3100.42.V32.D3	42	32	44	226	126	60			
V3100.43.V32.D3	43	32	44	229	129	60			
V3100.44.V32.D3	44	32	44	232	132	60			
V3100.45.V40.D3	45	40	54	245	135	70			
V3100.46.V40.D3	46	40	54	248	138	70			
V3100.47.V40.D3	47	40	54	251	141	70			
V3100.48.V40.D3	48	40	54	254	144	70			
V3100.49.V40.D3	49	40	54	257	147	70			
V3100.50.V40.D3	50	40	54	260	150	70			

Drill V3100 with inserts



DRILLING DEPTH 4xD / internal coolant supply 



Cylindrical shank with flat

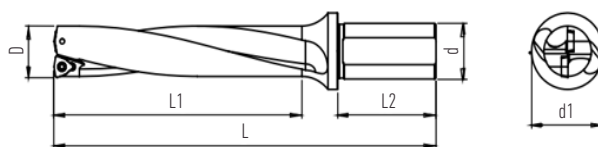
Order code	Dimensions (mm)							Insert	Screw	Key		
	D	d	d1	L	L1	L2						
V3100.15.5.V25.D4	15,5	25	34	142	62	56	WPMT 033208 (1,2 Nm)	TMSV-M2,5x6	T08			
V3100.16.V25.D4	16	25	34	142	64	56						
V3100.17.V25.D4	17	25	34	146	68	56						
V3100.17,5.V25.D4	17,5	25	34	150	72	56						
V3100.18.V25.D4	18	25	34	150	72	56						
V3100.19.V25.D4	19	25	34	154	76	56						
V3100.19,5.V25.D4	19,5	25	34	159	80	56						
V3100.20.V25.D4	20	25	34	159	80	56	WPMT 043208 (1,2 Nm)	TMSV-M2,5x7	T08			
V3100.21.V25.D4	21	25	34	164	84	56						
V3100.22.V25.D4	22	25	34	169	88	56						
V3100.23.V25.D4	23	25	34	174	92	56						
V3100.23,5.V25.D4	23,5	25	34	174	94	56						
V3100.24.V25.D4	24	25	34	177	96	56						
V3100.25.V25.D4	25	25	34	181	100	56						
V3100.25,5.V25.D4	25,5	25	34	181	102	56	WPMT 053308 (1,9 Nm)	TMSV-M3x8	T10			
V3100.26.V25.D4	26	25	34	186	104	56						
V3100.27.V25.D4	27	25	34	191	108	56						
V3100.27,5.V25.D4	27,5	25	34	191	110	56						
V3100.28.V25.D4	28	25	34	196	112	56						
V3100.29.V25.D4	29	25	34	201	116	56						
V3100.30.V32.D4	30	32	44	210	120	60				WPMT 063308 (2,9 Nm)	TMSV-M3,5x10	T15
V3100.31.V32.D4	31	32	44	215	124	60						
V3100.31,5.V32.D4	31,5	32	44	220	126	60						
V3100.32.V32.D4	32	32	44	220	128	60	WPMT 063308 (2,9 Nm)	TMSV-M3,5x10	T15			
V3100.33.V32.D4	33	32	44	225	132	60						
V3100.33,5.V32.D4	33,5	32	44	225	134	60						
V3100.34.V32.D4	34	32	44	230	136	60						
V3100.35.V32.D4	35	32	44	235	140	60						
V3100.36.V32.D4	36	32	44	238	144	60						
V3100.37.V32.D4	37	32	44	241	148	60						
V3100.38.V32.D4	38	32	44	244	152	60						
V3100.38,5.V32.D4	38,5	32	44	247	164	60						
V3100.39.V32.D4	39	32	44	247	172	60						
V3100.40.V32.D4	40	32	44	250	173	60						
V3100.41.V32.D4	41	32	44	253	173	60						
V3100.41,5.V32.D4	41,5	32	44	256	180	60						
V3100.42.V32.D4	42	32	44	256	168	60						
V3100.43.V32.D4	43	32	44	259	172	60	WPMT 083412 (4,3 Nm)	TMSV-M4x11	T15			
V3100.44.V32.D4	44	32	44	262	176	60						
V3100.45.V40.D4	45	40	54	265	180	70						
V3100.46.V40.D4	46	40	54	268	184	70						
V3100.47.V40.D4	47	40	54	271	188	70						
V3100.48.V40.D4	48	40	54	274	192	70						
V3100.49.V40.D4	49	40	54	277	196	70						
V3100.50.V40.D4	50	40	54	280	200	70						

* Drilling tolerance + - 0,2 mm

Drill V3100 with inserts



DRILLING DEPTH 5xD / internal coolant supply 



Cylindrical shank with flat

Order code	Dimensions (mm)						Insert	Screw	Key
	D	d	d1	L	L1	L2			
V3100.16.V25.D5	16	25	34	153	80	56	WPMT 033208 (1,2 Nm)	TMSV-M2,5x6	T08
V3100.17.V25.D5	17	25	34	158	85	56			
V3100.18.V25.D5	18	25	34	163	90	56			
V3100.19.V25.D5	19	25	34	168	95	56	WPMT 043208 (1,2 Nm)	TMSV-M2,5x7	
V3100.20.V25.D5	20	25	34	174	100	56			
V3100.21.V25.D5	21	25	34	180	105	56			
V3100.22.V25.D5	22	25	34	186	110	56	WPMT 053308 (1,9 Nm)	TMSV-M3x8	T10
V3100.23.V25.D5	23	25	34	192	115	56			
V3100.24.V25.D5	24	25	34	196	120	56			
V3100.25.V25.D5	25	25	34	200	125	56			
V3100.26.V25.D5	26	25	34	206	130	56			
V3100.27.V25.D5	27	25	34	212	135	56			
V3100.28.V25.D5	28	25	34	218	140	56	WPMT 063308 (2,9 Nm)	TMSV-M3,5x10	T15
V3100.29.V25.D5	29	25	34	224	145	56			
V3100.30.V32.D5	30	32	44	233	150	60			

* Drilling tolerance + - 0,2 mm

Drills V3100 with inserts



DRILLING DEPTH 2xD/3xD/4xD/5xD

Recommended cutting conditions

ISO	Material	HB	Vc (m/min)	Feed fz (mm/t)				
				WPMT03	WPMT04	WPMT05	WPMT06	WPMT08
				D15,5 - D21,5	D22 - D25,5	D26 - D30	D31 - D39	D40 - D50
P	Nelegovaná ocel, žíhaná	< 180 HB	110 - 220	0,06 - 0,09	0,06 - 0,11	0,07 - 0,13	0,08 - 0,18	0,10 - 0,25
	Nízkolegovaná ocel, žíhaná	180 - 280 HB	90 - 140	0,06 - 0,09	0,06 - 0,11	0,07 - 0,13	0,08 - 0,18	0,10 - 0,25
	Vysoce legovaná a nástr., žíhaná	280 - 350 HB	70 - 120	0,05 - 0,07	0,05 - 0,09	0,06 - 0,11	0,07 - 0,14	0,08 - 0,17
M	Nerezové oceli	< 200 HB	60 - 140	0,05 - 0,09	0,05 - 0,10	0,06 - 0,13	0,07 - 0,15	0,08 - 0,18
K	Šedá litina < 1000 N/mm ²	< 350 Mpa	100 - 160	0,07 - 0,11	0,07 - 0,13	0,08 - 0,15	0,09 - 0,18	0,11 - 0,22
	Tvárná litina	< 450 Mpa	90 - 120	0,06 - 0,10	0,06 - 0,12	0,07 - 0,14	0,08 - 0,16	0,10 - 0,20
S	Vysoce legované oceli	-	25 - 50	0,03 - 0,05	0,03 - 0,06	0,04 - 0,08	0,05 - 0,10	0,06 - 0,12
H	Superslitiny	-	25 - 50	0,03 - 0,05	0,03 - 0,06	0,04 - 0,08	0,05 - 0,10	0,06 - 0,12

*Cutting condition are recommended for drill body 2xD/3xD

For 4xD reduce condition by 10%

For 5xD reduce condition by 15%

Order code	P	M	K	S	H
WPMT033208-M PKU35	●	●	●	○	○
WPMT033208-M PKS38	●	●	●	●	●
WPMT033208-M PKT38	●	●	●	●	●
WPMT033208-M PKS48	●	●	●	●	

Order code	P	M	K	S	H
WPMT043208-M PKU35	●	●	●	○	○
WPMT043208-M PKS38	●	●	●	●	●
WPMT043208-M PKT38	●	●	●	●	●
WPMT043208-M PKS48	●	●	●	●	
WPMT043208-S PKU35	●	●	●	○	○
WPMT043208-S PKS38	●	●	●	●	●
WPMT043208-S PKT38	●	●	●	●	●
WPMT043208-S PKS48	●	●	●	●	

Order code	P	M	K	S	H
WPMT053308-M PKU35	●	●	●	○	○
WPMT053308-M PKS38	●	●	●	●	●
WPMT053308-M PKT38	●	●	●	●	●
WPMT053308-M PKS48	●	●	●	●	
WPMT053308-S PKU35	●	●	●	○	○
WPMT053308-S PKS38	●	●	●	●	●
WPMT053308-S PKT38	●	●	●	●	●
WPMT053308-S PKS48	●	●	●	●	

Order code	P	M	K	S	H
WPMT063308-M PKU35	●	●	●	○	○
WPMT063308-M PKS38	●	●	●	●	●
WPMT063308-M PKT38	●	●	●	●	●
WPMT063308-M PKS48	●	●	●	●	
WPMT063308-S PKU35	●	●	●	○	○
WPMT063308-S PKS38	●	●	●	●	●
WPMT063308-S PKT38	●	●	●	●	●
WPMT063308-S PKS48	●	●	●	●	

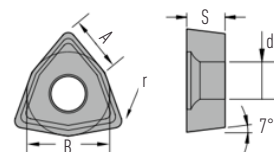
Order code	P	M	K	S	H
WPMT083412-M PKU35	●	●	●	○	○
WPMT083412-M PKS38	●	●	●	●	●
WPMT083412-M PKT38	●	●	●	●	●
WPMT083412-M PKS48	●	●	●	●	
WPMT083412-S PKU35	●	●	●	○	○
WPMT083412-S PKS38	●	●	●	●	●
WPMT083412-S PTS38	●	●	●	●	●
WPMT083412-S PKS48	●	●	●	●	

● = 1.choice

○ = 2.choice

Dimensions (mm)

Insert	A	B	S	r	d1
WPMT 033208	3,8	5,56	2,38	0,8	2,8
WPMT 043208	4,3	6,35	2,38	0,8	3
WPMT 053308	5,4	7,94	3,18	0,8	3,4
WPMT 063308	6,5	9,53	3,97	0,8	4
WPMT 083412	8,7	12,7	4,76	1,2	4,3



Blade shape



sharp geometry

Blade shape



low cutting force



Address

Plzeňská 610, 338 05 Mýto

 tgs@tgs.cz

Address

Plzeňská 610, 338 05 Mýto

www.tgs.cz